

Work Order ID 92118

Tuesday, October 23, 2012 4:09:46 PM

92118

Page 1

Item ID: PB67-43001-15

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Fwf Adjustable Blade Support Assembly

Start Date: 10/23/2012 Start Qty: 4.00 ***4***

Cust Item ID:

Required Date: 11/2/2012 Req'd Qty: 4.00 ***4***

Customer:

Reference:

Approvals: Process Plan: ML5 Date: 12-10-25 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
B67-43001-15	Rev C

100 0.00

100

Large Fab

Large Fab

Memo

0.00

Large Fab

1- make a 0.090" chamfer in the 1.00" hole before welding

2- assemble parts and weld as per dwg

3- grind weld flush in area of PB67-43001-249 only

4- install helicol insert as per dwg

(4x) CC 12-12-5

110

QC9- Inspect visual per QSI004- Fusion Welds / 0.00

110

QC

Memo

0.00

Quality Control

(4) 12-12-07

D45
09
8-89

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Item ID: PB67-43001-15 Accept ***N900040100*** Setup Start ***NS1***
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 Required Date: 11/2/2012 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120 *120* QC Quality Control	QC5- Inspect part completeness to step on W/O ✓ Memo	0.00 0.00				(4) 12-12-07			DAS 09 9-89
----------------------------------------------	-------------------------------------------------------------	------------------	--	--	--	--------------	--	--	-------------------

150 *150* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				4 12/12/10			
-----------------------------------------------------	-----------------------------------------------------	------------------	--	--	--	------------	--	--	--

160 *160* Powdercoat Powder Coating	Green Sandtex(Ref:4.3.5.8) per QSI005 4.3 Memo	0.00 0.00				4X ✓			mz 12/12/11
-----------------------------------------------------	-------------------------------------------------------	------------------	--	--	--	------	--	--	----------------

8:30 - MASK TUBE FROM BASE TO GUSSET START TIME:
 OVEN TEMPERATURE: 320°F FINISH
 TIME: 9:20

W18144

26

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Revision ID:

Stop ***NS2***

Item Name: Fwf Adjustable Blade Support Assembly

Start Date: 10/23/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 11/2/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC3- Inspect Part Finish	0.00							
170									
QC	Memo	0.00							
Quality Control									
180		0.00							
180	Small Fab								
Small Fab	Memo	0.00							
Small Fab	1- match drill cover to existing holes in support2- assemble as per dwg								
190	QC5- Inspect part completeness to step on W/O	0.00							
190									
QC	Memo	0.00							
Quality Control									

DAS
15
2-89
101212

4 ✓ f 24 actual

4 8 12-12-11

4

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Item ID: PB67-43001-15 Accept ***N900040100*** Setup Start ***NS1***
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 Required Date: 11/2/2012 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	Identify as per dwg & Stock Location: <i>WA</i>	0.00				<i>4</i>	<i>0</i>		<i>h</i>
200									
Packaging	Memo	0.00							<i>12-12-12</i>
Packaging									
210	QC21- Final Inspection - Work Order Release	0.00							
210									<i>12/12/13</i>
QC	Memo	0.00							
Quality Control									

12-12-12

Picklist Print

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Work Order ID: 92118

Parent Item: PB67-43001-15

Parent Item Name: Fwf Adjustable Blade Support Assembly

Start Date: 10/23/2012

Required Date: 11/2/2012

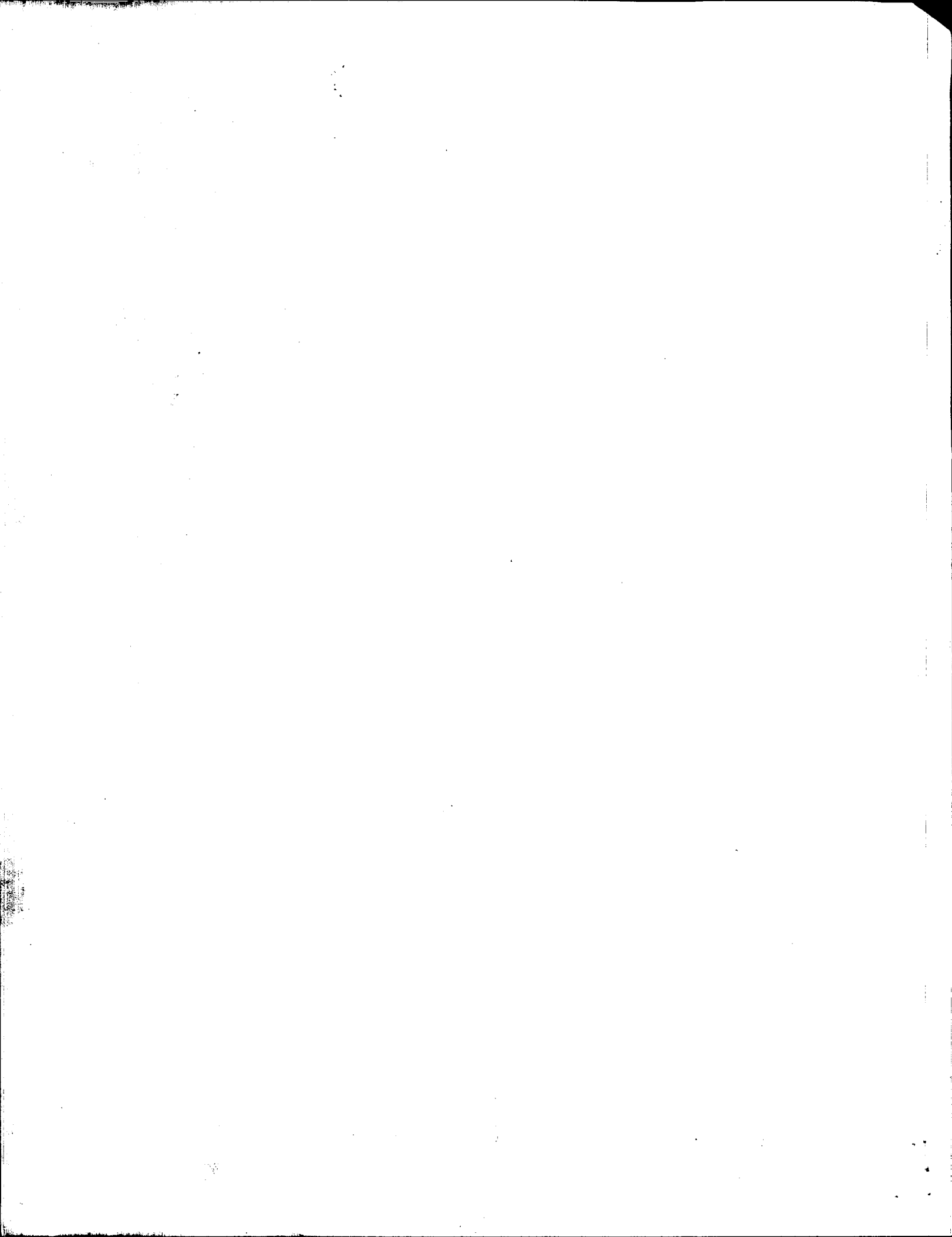
Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 08-06-26 new issue DD verified by:ec
dwg EC verified by:DD

IPP Rev B 10.09.28 per rev C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
PB67-43001-71 20° Blade Support Assembly		Manufactured	No				Each	1.0000		4		CC 12.12.5	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST437A		1		B92085			(4X)		
				41512		1							
PB67-43001-249 Inner Tube Bushing		Manufactured	No			100	Each	3.0000	1	4		CC 12-12-5	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST438		3		B90927			(4X)		
				52480		3							
PB67-43001-253 Gusset		Manufactured	No			100	Each	7.0000	1	4		CC 12-12-5	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		7		B90928			(4X)		
				85185		7							
PB67-43001-254 Gusset		Manufactured	No			100	Each	16.0000	1	4		CC 12-12-5	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST438		16		B			(4X)		
				52481		16							
PB67-43001-257 Inner Tube		Manufactured	No			100	Each	0.0000	1	4		CC 12-12-5	
MS124780 HELICAL INSERT		Purchased	No			180	Each	82.0000	1	4		12.12.06	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST333		82		B90930			(4X)		
				111064		82							
										4			



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Work Order ID: 92118

Parent Item: PB67-43001-15

Start Date: 10/23/2012

Required Date: 11/2/2012

Parent Item Name: Fwf Adjustable Blade Support Assembly

Start Qty: 4.00

Required Qty: 4.00

MS27039-1-10

Screw

Purchased No

180 Each 416.0000 8

32 *m/d 3522 SP*

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
308	8	
122441	8	
GA	100	
120449	100	
ST291	5	
120120	5	
ST305	300	
122815	300	
ST308	3	
122027	3	

NAS1149D0316J

Washer

Purchased No

180 Each 400.0000 8

32 *SP*

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST298	400	
122151	400	

m/d 3482 32x

NAS1149D0363J

Washer

Purchased No

180 Each 4,785.0000 8

32 *SP 12-12-7*

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST294	1854	
123248	1254	
123355	600	
ST297	2820	
122378	2820	
ST298	111	
117601	61	
119537	33	
120308	17	

32x

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Work Order ID: 92118

Parent Item: PB67-43001-15

Parent Item Name: Fwf Adjustable Blade Support Assembly

Start Date: 10/23/2012

Required Date: 11/2/2012

Start Qty: 4.00

Required Qty: 4.00

PB67-43001-73

20-Degree Cover Plate

Manufactured No

180 Each 5.0000

1

4

SP-

Location

Loc Qty

Loc Code

ST437A

5

53305

5

4X

Manufactured No

180 Each 5.0000

1

SP12-12-7.

Location

Loc Qty

Loc Code

ST444

5

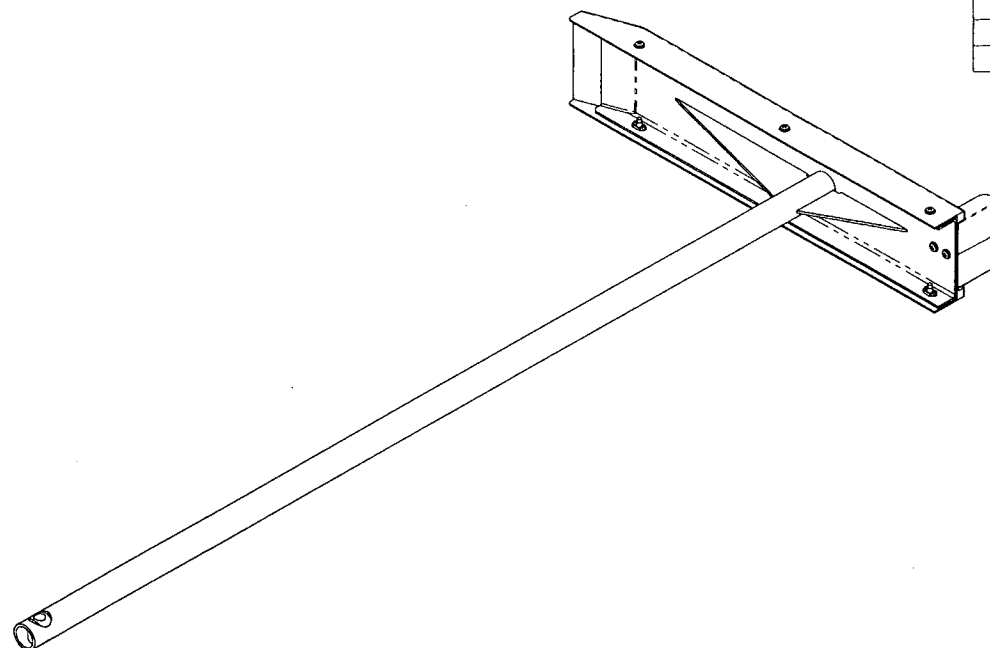
53240

5

4X

PB67-43001-83

PB67-43001-83



B67-43001-15 FWD ADJUSTABLE BLADE SUPPORT ASSY

ITEM	QTY -15	P/N	DESCRIPTION
1	X	B67-43001-15	FWD ADJUSTABLE BLADE SUPPORT ASSEMBLY
2	1	B67-43001-15W	FWD ADJUSTABLE BLADE SUPPORT WELDMENT
3	1	B67-43001-73	20" COVER PLATE
4	1	B67-43001-83	SHORT D-PAD ASSY
5	8	MS27039-1-10	SCREW
6	8	NAS1149D0316J	WASHER
7	6	NAS1149D0363J	WASHER

COPY
 RETURN TO
 REWORKING
 CONTROLLED COPY
 FOR AMENDMENT
 PART NOTICE
 ORDER
 92118 MLJ
 12-10-25

RELEASED
 2010-09-16
MD

C		REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 7 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	10.04.28
REV.	DESCRIPTION			BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. B67-43001-15 TITLE FWD ADJUSTABLE BLADE SUPPORT ASSY SCALE NTS DATE 10.04.28			REV. C
DRAWN					SHEET 1 OF 2
CHECKED					
MFG. APPR.					
APPROVED					
DE APPR.	N/A				
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8

7

6

5

4

3

2

1

B67-43001-15W FWD ADJUSTABLE
BLADE SUPPORT WELDMENT
REF

NAS1149D0363J
WASHER

MS27039-1-10 SCREW [8]
NAS1149JD0316J WASHER

B67-43001-73
20" COVER PLATE
REF

SECTION A-A B7-2
SCALE 4X, 6 PL

B67-43001-73
20" COVER PLATE

B67-43001-15W FWD ADJUSTABLE
BLADE SUPPORT WELDMENT

MS27039-1-10 SCREW
NAS1149JD0316J WASHER
2 PL [8]

B67-43001-15 FWD ADJUSTABLE BLADE SUPPORT ASSY

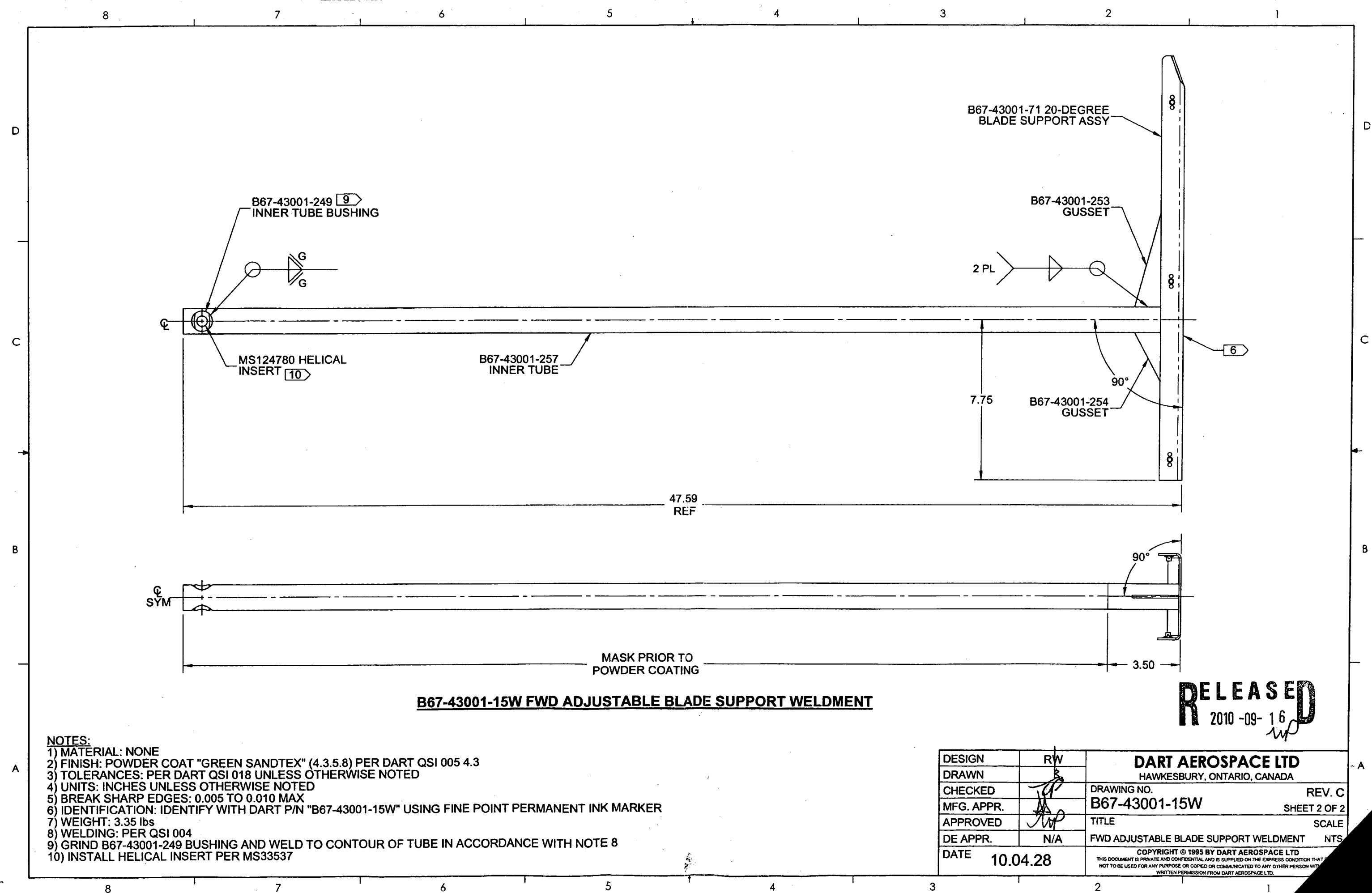
B67-43001-83
D-PAD ASSEMBLY, SHORT

RELEASED
2010-09-16

NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 8.70 lbs
- 8) LOCATE PARTS AS SHOWN AND TRANSFER DRILL $\phi 0.250$ TO $\phi 0.257$ HOLES FROM EXISTING HOLE PATTERNS ON B67-43001-15W AND B67-43001-83 TO B67-43001-73

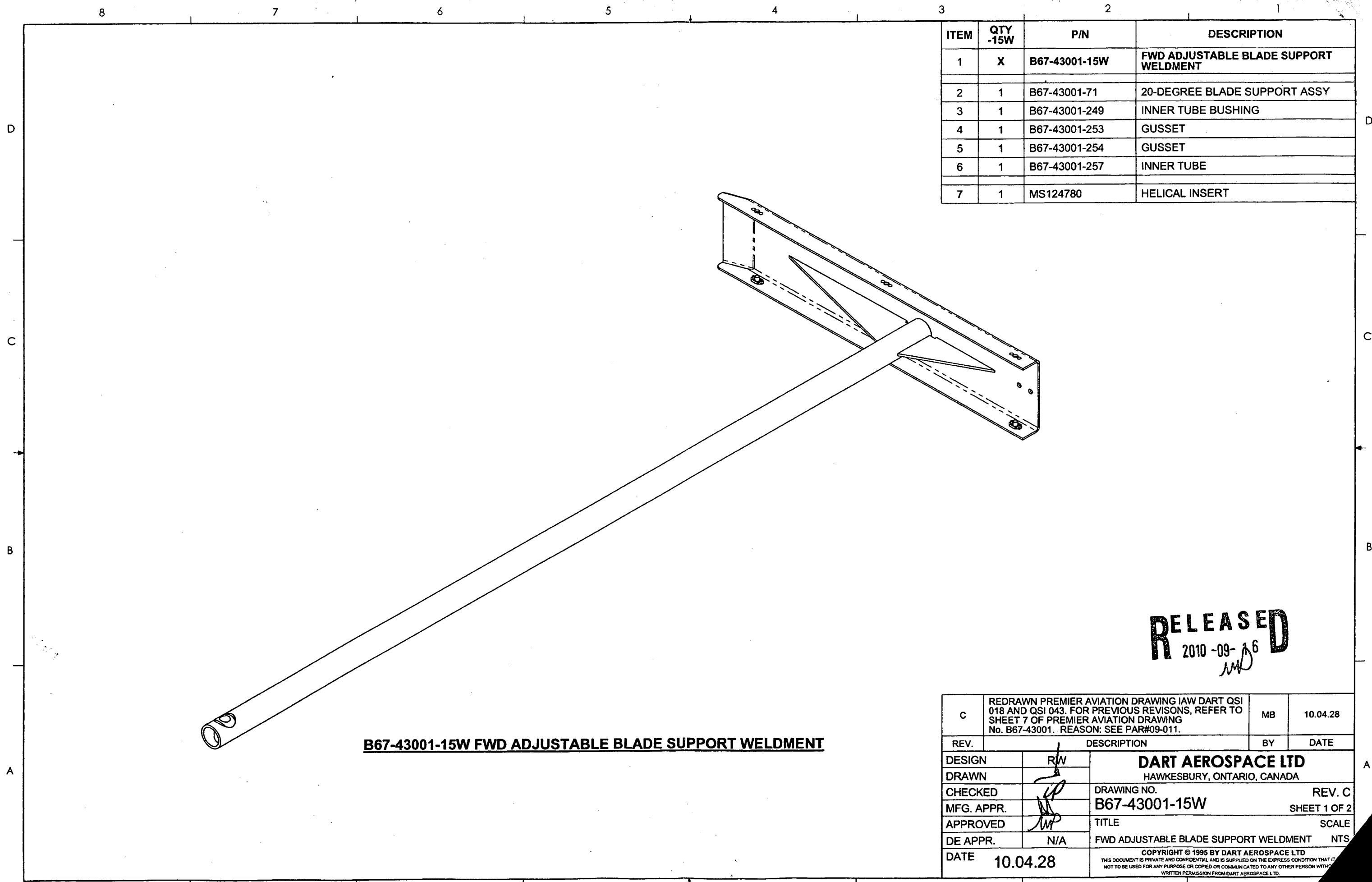
DESIGN	RW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		B67-43001-15	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.	N/A	FWD ADJUSTABLE BLADE SUPPORT ASSY	NTS
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NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: POWDER COAT "GREEN SANDTEX" (4.3.5.8) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "B67-43001-15W" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 3.35 lbs
- 8) WELDING: PER QSI 004
- 9) GRIND B67-43001-249 BUSHING AND WELD TO CONTOUR OF TUBE IN ACCORDANCE WITH NOTE 8
- 10) INSTALL HELICAL INSERT PER MS33537

DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		B67-43001-15W	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.	N/A	FWD ADJUSTABLE BLADE SUPPORT WELDMENT	NTS
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ITEM	QTY -15W	P/N	DESCRIPTION
1	X	B67-43001-15W	FWD ADJUSTABLE BLADE SUPPORT WELDMENT
2	1	B67-43001-71	20-DEGREE BLADE SUPPORT ASSY
3	1	B67-43001-249	INNER TUBE BUSHING
4	1	B67-43001-253	GUSSET
5	1	B67-43001-254	GUSSET
6	1	B67-43001-257	INNER TUBE
7	1	MS124780	HELICAL INSERT

B67-43001-15W FWD ADJUSTABLE BLADE SUPPORT WELDMENT

RELEASED
2010-09-16
MD

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 7 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	10.04.28
REV.	DESCRIPTION		BY	DATE
DESIGN	R/W	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	<i>[Signature]</i>	DRAWING NO. B67-43001-15W REV. C SHEET 1 OF 2		
CHECKED	<i>[Signature]</i>	TITLE FWD ADJUSTABLE BLADE SUPPORT WELDMENT SCALE NTS		
MFG. APPR.	<i>[Signature]</i>	DATE 10.04.28		
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